

Work Order ID 51387



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August 20, 2009 3:35:45 PM

Item ID:	D3195-041	Accept		Setup	Start			
Revision ID:	A				Stop			
Item Name:	Bracket Assembly							
Start Date:	21/08/2009	Start Qty: 8.00		Cust Item ID:				
Required Date:	27/08/2009	Req'd Qty: 8.00		Customer:				
Reference:	<i>Start 09-08-20</i>					Run	Start	
Approvals:	Process Plan:	Date:	Tooling:	Date:		Stop		
	QC:	Date:	SPC (Y/N):	Date:				

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3195	Rev A								
100 	BAND SAW	0.00				8	0		
Bandsaw	Memo	0.00							
Jeaspa Bandsaw	Cut blanks: (0.75" x 2.00") x 3.60" long								
110 	HAAS CNC VERTICAL MACHINING #1	0.00							
HAAS 1	Memo	0.00							
HAAS CNC vertical machine #1	Machine D3195-1 as per Folio FA334 and Dwg D3195-1 Identify as D3195-1 Deburr								
120 	QC2- Inspect parts off machine FAI/FAIB	0.00							
QC	Memo	0.00							
Quality Control									

*H.A 09/08/20**H.A 09/08/20**H.A 09/08/20*

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Item ID: D3195-041

Accept



Setup Start



Revision ID: A

Stop



Item Name: Bracket Assembly

Start Date: 21/08/2009 Start Qty: 8.00



Cust Item ID:

Required Date: 27/08/2009 Req'd Qty: 8.00



Customer:

Reference:

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start
	QC:	Date:	SPC (Y/N):	Date:	Stop	



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130 QC8- Inspect parts - second check

0.00

QC

Quality Control

Memo

0.00

m= 09/08/21

8

0

140

HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

0.00

x8 mb 09/08/21

150

Powdercoat

Powder Coating

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

Memo

0.00

=> m 09/08/26

x8

0

 START TIME: 7:30 AM OVEN TEMPERATURE:
800°F FINISH TIME: 520°F

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Cust Item ID:

Required Date: 27/08/2009 Req'd Qty: 8.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160



QC3- Inspect Part Finish

0.00

BR 09-08-26

(8)

QC

Memo

0.00

Quality Control

170



Small Fab

0.00

Small Fab

Memo

0.00

Small Fab

1-Lightly Sand bonding surface □ 2-Bond D3195-5 into D3195-1 as per Dwg
D3195 □ A/R Contact Cement 1109109

180



QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

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Setup Start



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Stop



Item Name: Bracket Assembly

Start Date: 21/08/2009 Start Qty: 8.00



Cust Item ID:

Required Date: 27/08/2009 Req'd Qty: 8.00



Customer:

Reference:

Approvals: Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center ID

190



Packaging

Packaging

Operation
DescriptionIdentify as per dwg & Stock Location: 246ASet Up/
Run Hours

0.00

Draw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

200



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

9/8/28 8x SP

09/08/31 JJ

BL 09-8-28 (8)

Picklist Print

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Work Order ID: 51387



Parent Item: D3195-041RevA



Parent Item Name: Bracket Assembly

Start Date: 21/08/2009

Required Date: 27/08/2009

Comments:

Start Qty: 8.00

Required Qty: 8.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3195-5RevA		Manufactured	No			100	Each	5.0000	8.0000		26/08/27	

Pad

WarehouseLocationLoc QtyLoc Code

Main Warehouse

ST

5

31533

5

5

M6061T6B0.750X02.00

Purchased

No

170

f

53.0000 2.5263

0

6061-T6 Bar .750 x 2.00

WarehouseLocationLoc QtyLoc Code

Main Warehouse

MAT

53

100742

11.5

111448

40

18571

1.5

2.5263

y.A 09/08/20

DART AEROSPACE LTD	Work Order:	51387
Description: Bracket	Part Number:	D3195-1
Inspection Dwg: D3195 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	J.A
Date:	09/08/20

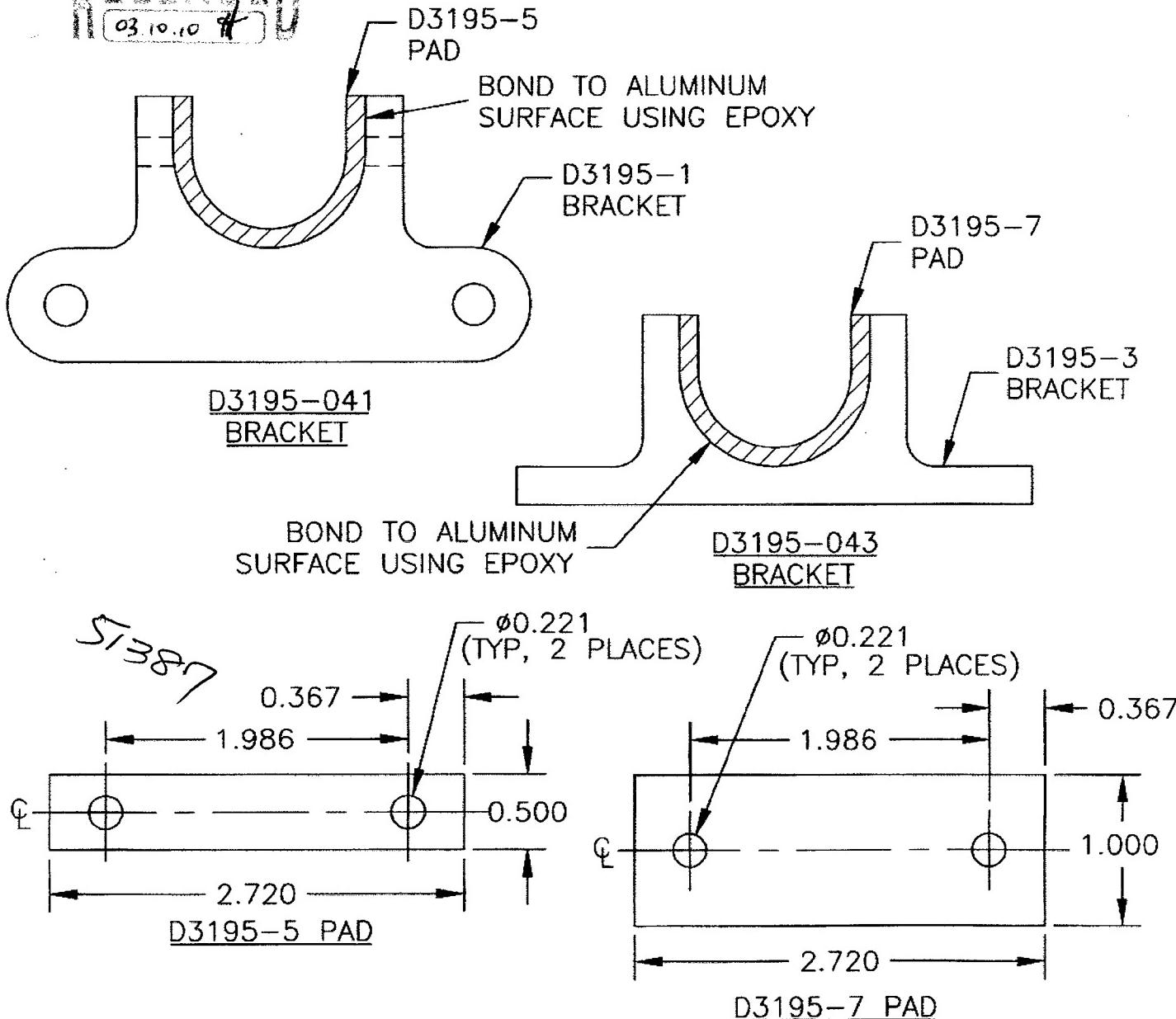
Audited by:	<u>Murphy</u>
Date:	09/08/2011

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.04.20	New Issue (P/O D412-702-011/-13)	KJ/RF	TT

DART

DESIGN	CP	DRAWN BY	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	#	APPROVED	#	DRAWING NO. D3195
DATE	03.06.23			REV. A SHEET 1 OF 3
		TITLE	BRACKET	SCALE 1:1
A	03.06.23	NEW ISSUE		

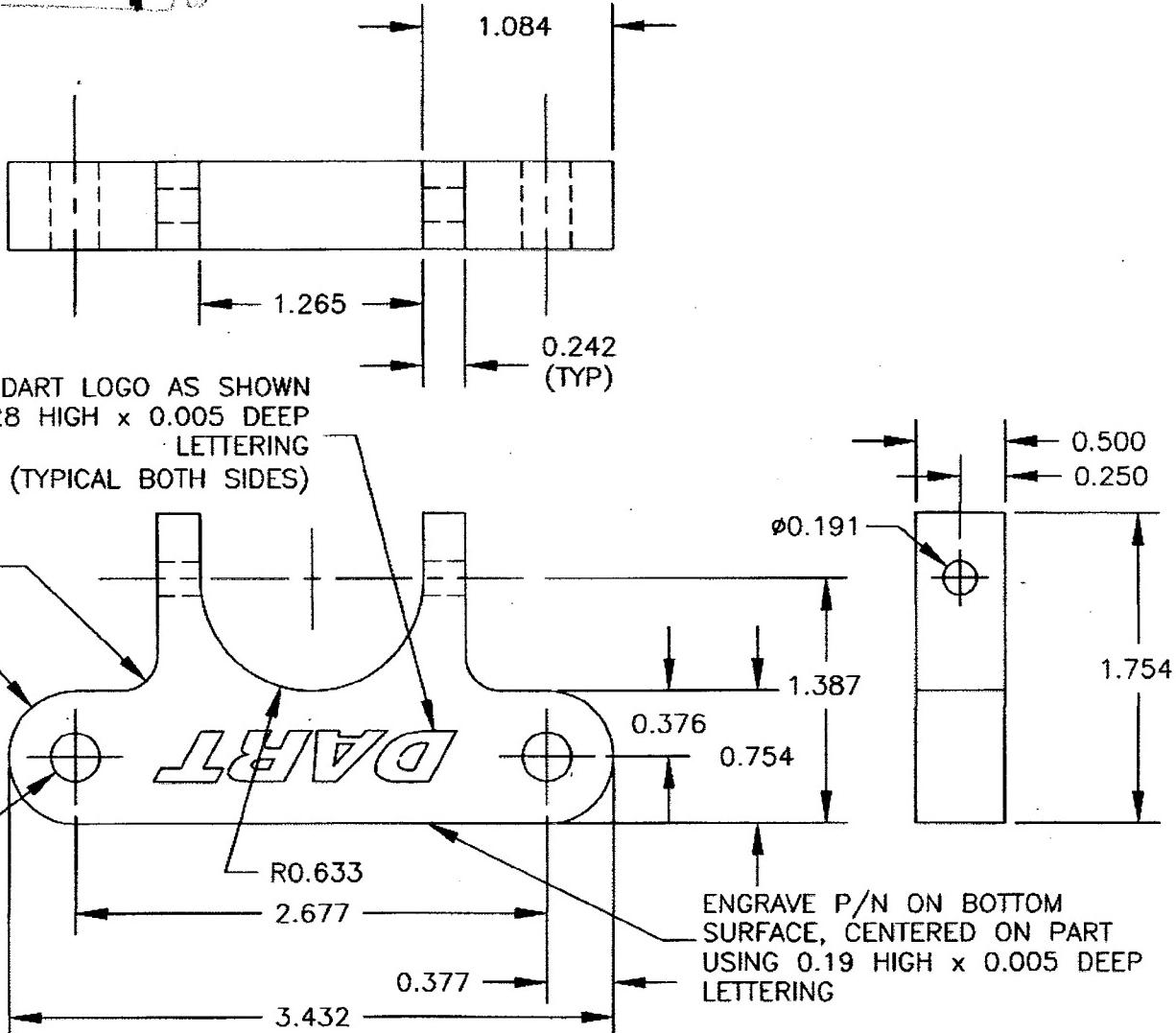
RELEASED
03.10.10 #10D3195-5 & D3195-7 PAD

- 1) MATERIAL: 60 DUROMETER NEOPRENE 1/8" THICK
(POSSIBLE SUPPLIERS, ACCURATE RUBBER)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 3) ALL DIMENSIONS ARE IN INCHES

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. A
		D3195	SHEET 2 OF 3
DATE	TITLE	SCALE	
03.06.23	BRACKET	1:1	

RELEASED
03.06.10

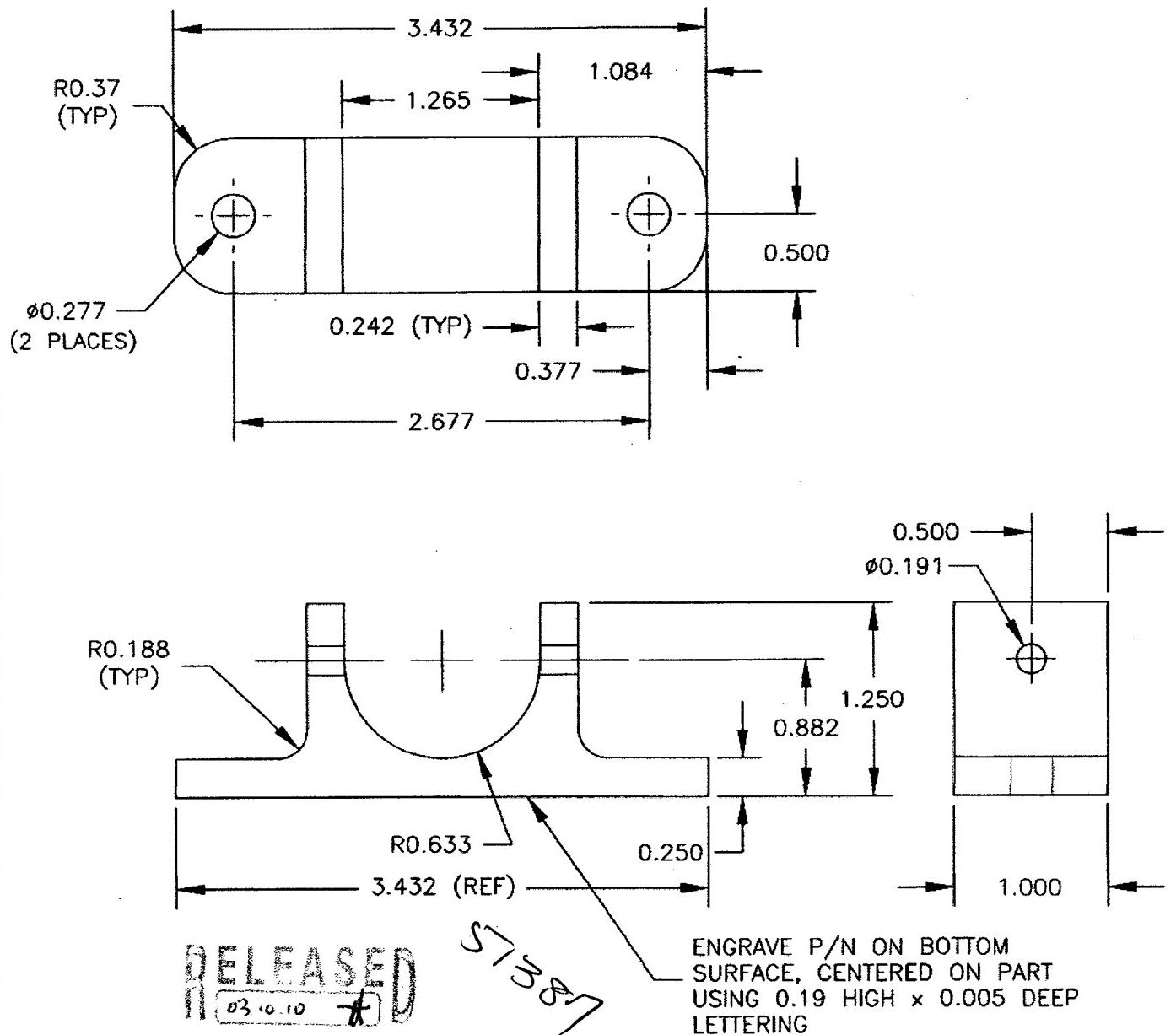


D3195-1 BRACKET

- 1) MATERIAL: 6061-T6/T651 (QQ-A-250/11 OR QQ-A-200/8 OR QQ-A-225/8)
(REF. DART SPEC M6061T6S OR M6061T6B)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD	
CHECKED	APPROVED	DRAWING NO.	HAWKSBURY, ONTARIO, CANADA
		D3195	REV. A
DATE	TITLE	SHEET 3 OF 3	
03.06.23	BRACKET	SCALE 1:1	

**D3195-3 BRACKET**

- 1) MATERIAL: 6061-T6/T651 (QQ-A-250/11 OR QQ-A-200/8 OR QQ-A-225/8)
(REF. DART SPEC M6061T6S OR M6061T6B)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES